

Date: Monday, 10/22/2007 10:34:37 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
Job Number : 35263
Estimate Number : 12577
P.O. Number : N/A Part Number : D3562042
This Issue : 10/22/2007 S.O. No. : N/A Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
Previous Run : 34270 Material : N/A
Written By : Due Date : 11/10/2007 Qty: 5 Um: Each
Checked & Approved By :
Comment : Est Rev A New Issue 06-11-09 JLM
Est rev B ECN 987 07.10.09 EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

B 34694 = 1
B 34016 = 4

Check Material for any Dents or Defects

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07.11.19 (5)

6.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100 Each(s)
ARM WELDMENT

B35030 a.m 07.11.19 5

7.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
ARM WELDMENT
Batch

B35032 a.m 07.11.19 5

8.0

MS20600AD4W4

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)
Blind Rivet
batch: M105953

this line acceptable a.m 07.11.22 5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

PTU

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

a.m 07.11.22 5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07.11.22 (4)

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 D2734 End Cap B34485

07.11.22 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: N/A Fault Category: Prod/Eng ass ^{medel smitt} NCR: Yes No DQA: D Date: 07/11/29
 QA: N/C Closed: H Date: 07.11.29

NCR: <u>35263</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-20	9.0	RH Arms were assembled onto the step as LH (per Dwg) Qty 1 step. R.C.: Employee error	<i>[Signature]</i> 05/10/22	Remove step arms: rivets. Ensure not to damage arms or step when separating the magna bond. * Carefully remove magna bond from step: step arms. Verify by R.C. re-Assemble as per Dwg instructions	<i>[Signature]</i> 07/11/20 N/A 07/11/20	<i>[Signature]</i> 07/11/22 07/11/20 07/11/22	<i>[Signature]</i> 05/10/22	<i>[Signature]</i> 07-11-20

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Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

07-11-22 4

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-11-23 (4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 ALU (4X)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Touch-up Alodine 07-11-26 (4X) M105914

m-l 07/11/26

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

BB 07-11-27

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 ALU (27)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

10/21/09

Job Completion



W 07.11.29

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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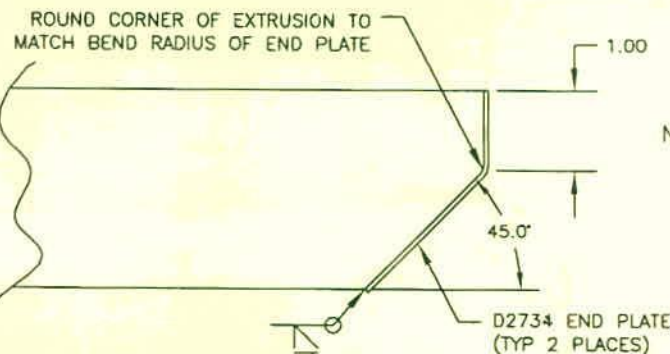
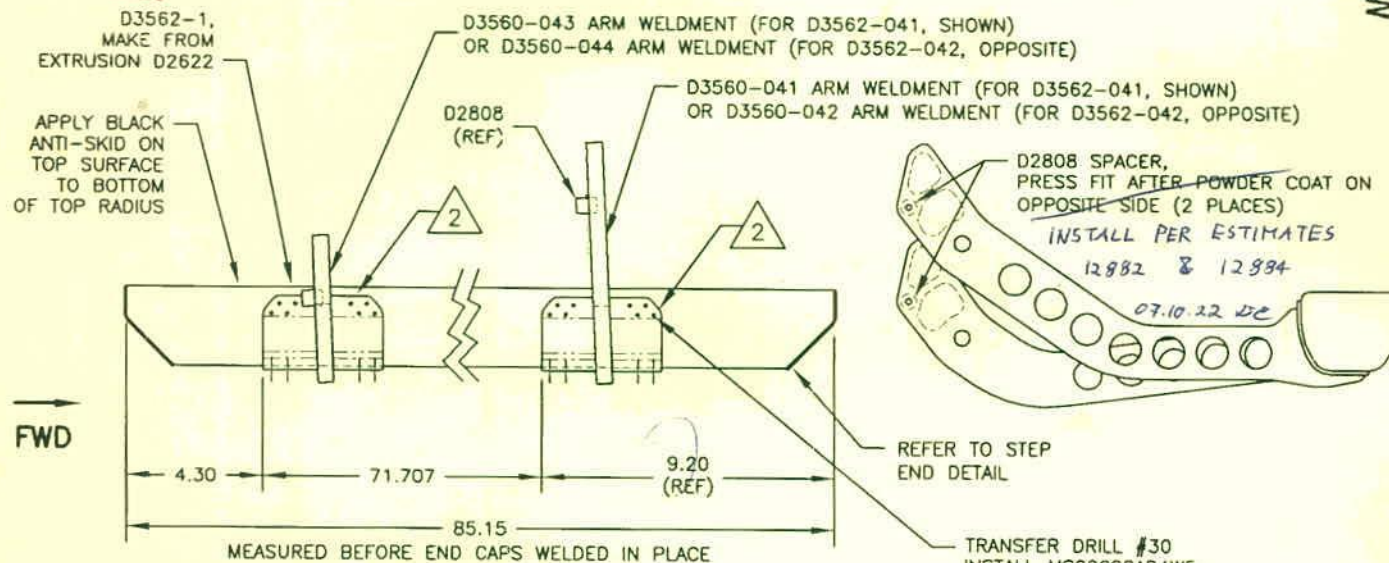
DART**RELEASED**
07.06.27-10**UNDER REVIEW**

07.10.22 DC

OK PER REV C

07.10.22 DC

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**TYPICAL STEP END DETAIL**
NOT TO SCALESHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 35263
WORK ORDER**D3562-041 LH STEP ASSEMBLY (SHOWN)**
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
07.06.19	06.09.26	NEW ISSUE	SCALE
07.01.15	ARMS NOW RIVETED TO STEP		SHEET 1 OF 1
07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS		NTS
CHECKED	APPROVED	DRAWING NO. D3562	
DATE	TITLE	STEP ASSEMBLY	

